

Date: Monday, 8/21/2006 2:13:59 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSEMBLY
Job Number : 28273	
Estimate Number : 10464	
P.O. Number : <i>N/A</i>	Part Number : D3278041
This Issue : 8/21/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27867	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/6/2006 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature] 06 08.21</i>	
Comment : Est:A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	28273A	SUPPORT
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Comment: Sub-Component SUPPORT

D3278-1 B *27867A (x8)* / *B24408 (x9)* / *B28273A (x23)*

FF 06-09-25

2.0	28273B	SUPPORT
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Comment: Sub-Component SUPPORT

D3278-2 B *27867B (x7)* / *B28273B (x34)*

FF 06-09-25

3.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty	Part Number
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1	D3278-3
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Description

Spacer

Batch

<i>B28274</i>

FF 06-09-25

4.0	MS20426AD37	RIVET
-----	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick: *[Signature]*

Qty	Part Number
-----	-------------

4	MS20426AD3-7
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Description

Rivet

Batch

<i>17694 M16527</i>

FF 06-09-25

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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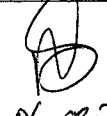

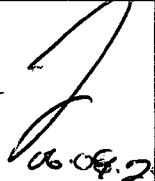


Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

FF 06-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/09/25	5	after drilling Rivet out of hole of D3278-2; hole Drill went off centre and hole became too large. (part scrap.	 06/09/25	destroy & replace b. <u>28273 B</u> x 1	FF 06/09/25	 06/09/25	 06/09/25	 06/09/25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:13:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 28273

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/25 (40)

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2230-1

Mounting Lug

328011

FF 06-09-26 40

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-13A

Bolt

M 101594

FF 06-09-26 40

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD416

Washer

M 19185

FF 06-09-26 40

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21042L4

Nut

M 19085 (x64) / M 19099 (x16) 06-09-26 40

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

FF 06-09-26 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:13:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 28273

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/3 06/09/27 (40)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57105

8/4/28 (40)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

8/6/09/27 (40)

Job Completion



U 06-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

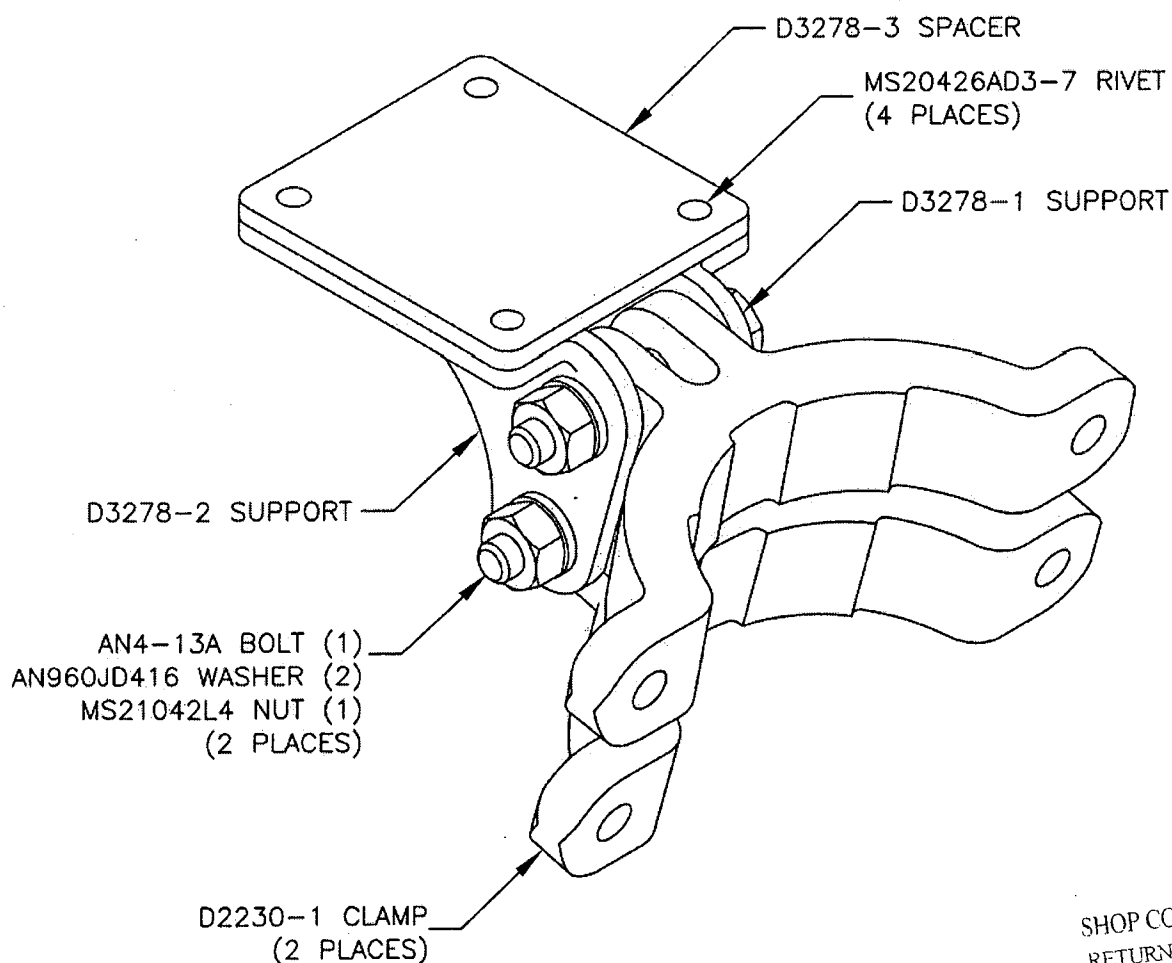
QA: N/C Closed: _____ Date: _____



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				D3278	SHEET 1 OF 3
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE	NTS
A	04.03.03	NEW ISSUE			
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT			

RELEASED
05.04.04 *[Signature]*

D3278-041 SUPPORT ASSEMBLY



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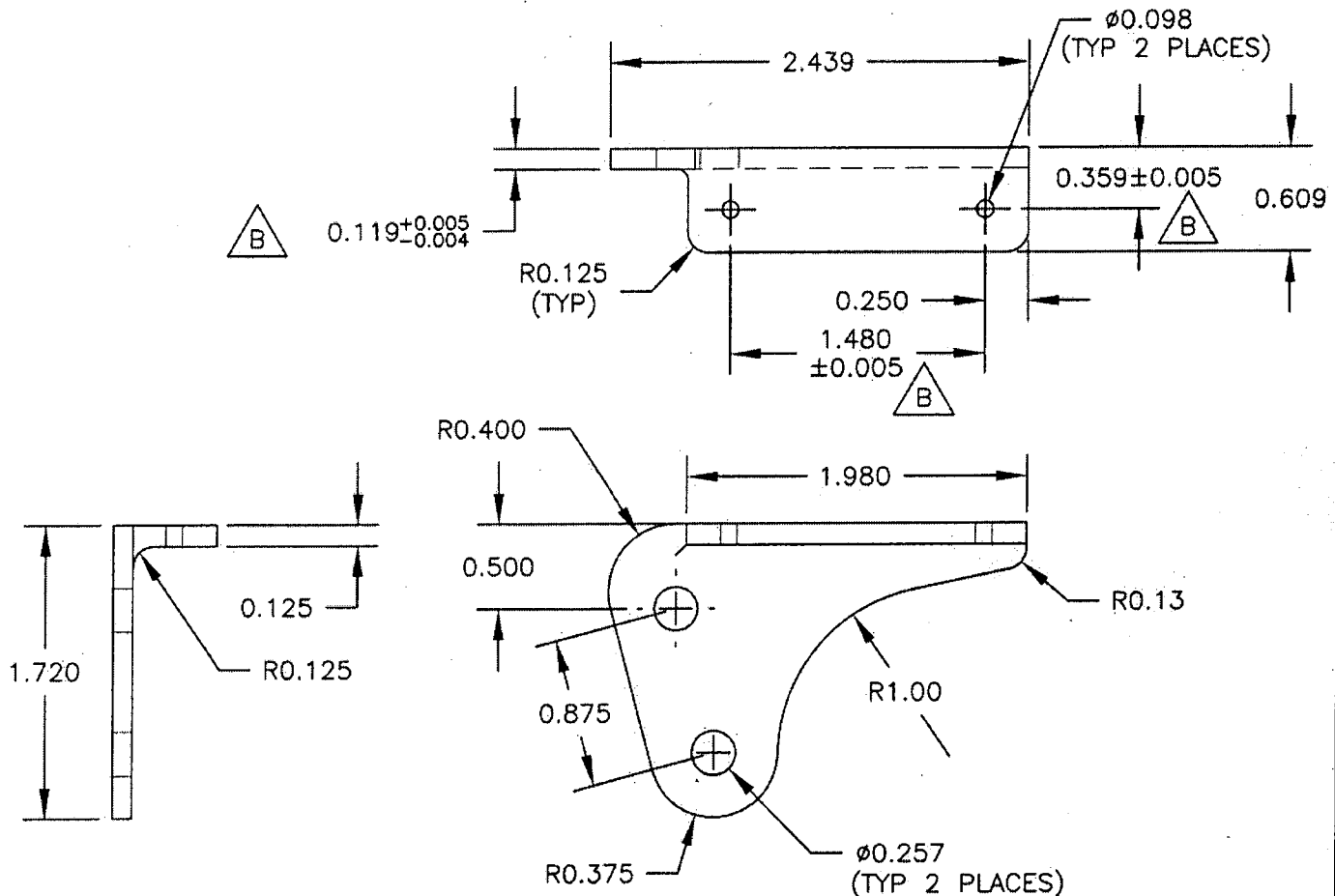
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DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE	1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR1"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/19)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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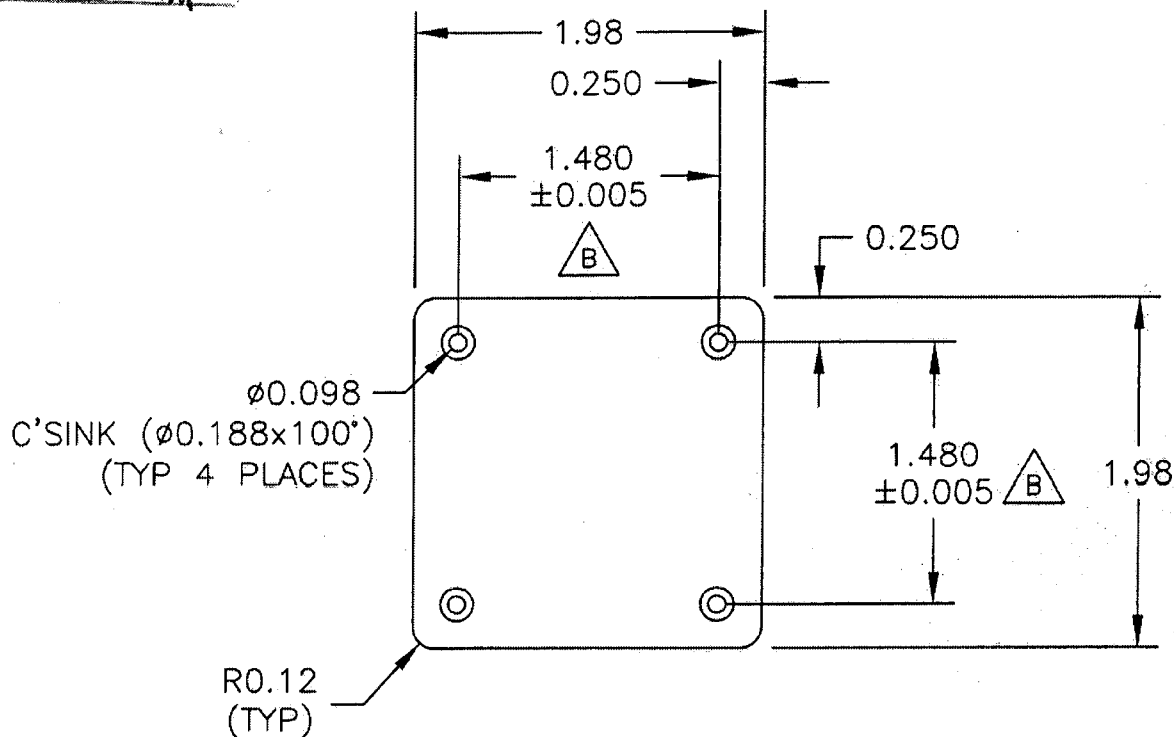
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04 [Signature]



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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